User:

Monday, 1/8/2007 10:50:01 AM

Kim Johnston

## **Process Sheet**

Customer

: CU-DAR001 Dart Helicopters Services

**Job Number Estimate Number**  : 30148

: 10425

P.O. Number

:NIA

This Issue

: 1/8/2007

: NC

: NIA : 29980

S.O. No. : NIA

Type

: SMALL /MED FAB

**Part Number Drawing Number** 

**Drawing Name** 

: D32191 : D3219 REV A

: PLATE

Project Number

: N/A

**Drawing Revision** 

Material : 1/20/2007 **Due Date** 

Qty:

60 Um:

Each

Written By

Prsht Rev.

First Issue

**Previous Run** 

Checked & Approved By

Comment

New issue KJ/JLM : Est. ESR B 06.05.25 Waterjet

**Additional Product** 

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M6061T6S125

6061-T6 .125 Sheet

Comment: Qty.:

0.1012 sf(s)/Unit Total:

 $6.0732 \, sf(s)$ 

6061-T6 .125 Sheet

To be made in multiples of 4

Material: 6061-T6 (QQ-A-200/11) 0.125" thick (M6061T6S.125) Batch: M1866

2.0

WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3219

Dwg Rev: A

Prog Rev:\_

ml or 01 09

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

5.0

QC8

SECOND CHECK

Comment: SECOND CHECK

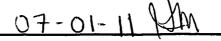


SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.







## **Dart Aerospace Ltd**

STEP	PROCEDURE CHANGE	Ву	Date		Approval	
	PROCEDURE CHANGE			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	· · · · · · · · · · · · · · · · · · ·					

Part No: _	 _PAR #:	Fault Category:	NCR: Yes No	DQA:	Date: 67/01/16
			QA: N/C C	losed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Varification		Annewal			
DATE	STEP	Section A			Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspecto	
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NOTE: Date & initial all entries

Date: Monday, 1/8/2007 10:50:01 AM User: Kim Johnston **Process Sheet** Drawing Name: PLATE Customer: CU-DAR001 Dart Helicopters Services Part Number: D32191 Job Number: 30148 Job Number: Description: Seq. #: **Machine Or Operation:** INSPECT WORK TO CURRENT STEP 6.0 QC5 Comment: INSPECT WORK TO CURRENT STEP PACKAGING 1 PACKAGING RESOURCE #1 7.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 574/6 QC21 8.0 Comment: FINAL INSPECTION/W/O RELEASE U 07.01.12 Job Completion

Dart Ae	rospace	e Ltd							
W/O:			W	ORK ORDER CHANGES	3				
DATE	STEP	PRO	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No <b>DQ</b>	A:	Date:	
					QA: N	/C Close	d:	_ Date: _	
NCR:			WORK ORD	ER NON-CONFORMAN	CE (NCF	R)			
		Description of NC		Corrective Action Section B	3	Verific	ration	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector
,									
							:		
	-				<del></del>			<del>                                     </del>	

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30148
Description: Plate	Part Number:	D3219-1
Inspection Dwg: D3219 Rev: A		Page 1 of 1

Inspection Dwg:	D3219 <b>Rev</b> :	<u> </u>			32.780, ·····		age i oi i
	FIRST	ARTICLE IN	NSPECTI	ON CHE	ECKLIST		
	X	First Artic	cle	Prot	otype		
Drawing	Tolerance	Actual	Accept	Reject	Method of Inspection	Co	omments
Dimension		Dimension					
Ø0.316	+0.005/-0.000	0.316	V		VerN		
2.293	+/-0.005	2.233	V,		Nern		
2.965	+/-0.010	2.964			VerN		
0.566	+/-0.010	0.566	1		Vern		
0.375	+/-0.010	0.375	1		vern		
R0.125	+/-0.010	RO.125	$\sqrt{}$		RADIUS GOVE	lar_	
0.125	+/-0.010	0.124	$\checkmark$		Vern	V 	
13.9	+/-0.010	13.9	$\sqrt{}$		Angle Ne	tec	
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Measured by: Date:	10109	Date:	D3(c	1/6	1 TOLOGY PE AP	Date:	N/A
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Measured by:	Audited by:	M	Prototype Approval:	N/A
Date: 07 01 09	Date:	07/01/09	Date:	N/A

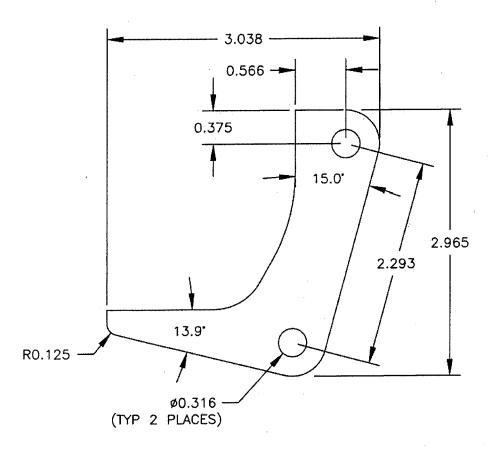
Rev	Date	Change	Revised by	Approved
Α	04.04.19	New Issue	KJ/JLM	





DESIG	a	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	)
CHECK	ED,	APPROVED,	DRAWING NO.	REV. A
	-#-	州	D3219 SHEE	T 1 OF 1
DATE		<u> </u>	TITLE	SCALE
03.1	0.10		PLATE	1:1
 Α		03,10,10	NEW ISSUE	





## D3219-1 PLATE

- 1) MACHINE PER DWG FILE "D3219-1.SLDPRT"
- 2) MATERIAL: 6061-T6, 0.125 THICK (QQ-A-250/11) (REF DART SPEC M6061T6S.125)
- FINISH: NONE
- BREAK ALL SHARP EDGES 0.005 TO 0.015
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT

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